

Work Order ID 78783

January-16-12 7:41:37 AM

78783

Page 1

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 16/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.L.J.

Date: 12/01/16 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3272	Rev B
-------	-------

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

0.00

M.L.J. 12/03/06

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

5/2/07

(10)

110

110

Large Fab

Large Fab

0.00

0.00

12/02/13 10 Ø

Large Fab

Memo
1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

119185
119112

3-Grind End Plate flush

0.00

0.00

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Start Date: 16/01/2012 **Start Qty:** 10.00

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Cust Item ID:

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

120

QC9- Inspect visual per QSI004- Fusion Welds

120

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

x 10

0

3E 12/02/15

0.00

130

QC5- Inspect part completeness to step on W/O

0.00

8 n/01/15

0.00

130

QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

140

HandFinish

Hand Finishing

x10
Rt

10X0 M/ 12/02/22
Rt

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

150

QC3- Inspect Part Finish

0.00

10 12/22/2012

150

QC

Memo

0.00

Quality Control

180

Large Fab

0.00

(X10) ✓

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

12/02/28

2-Leave one rivet out until welding is complete.

12/02/23

3-Bevel Aft end for welding



4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod 120/169

6-Grind End Plate flush

7-Install last rivet as per Dwg.

W/O:		WORK ORDER CHANGES						
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Required Date: 09/03/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

190

QC10- Inspect visual per QSI004- ground welds

190

QC

Quality Control

200

QC5- Inspect part completeness to step on W/O

200

QC

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

210

HandFinish

Hand Finishing

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

5.26.102

0.00

5.26.102

0.00

0.00

HC
Rte

10X M-12/03/05
RH

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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10

Cust Item ID:

Required Date: 09/03/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

220

220

Powdercoat

Powder Coating

**Operation
Description**

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10X1M-1 12/03/05
RH

M120220

230

230

HandFinish

Hand Finishing

Memo 10:15 0.00
START TIME: 10:15
OVEN TEMPERATURE: 3200°F
FINISH TIME: 10:45

240

240

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10 BL 123-5.

10 BL 4 M 12/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Setup

Start

NS1

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Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 16/01/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 09/03/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

250

250

Packaging

Packaging

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

0.00

12317 sd (10) 8/8/12

260

QC4- 100% Inspect kits for completeness

0.00

5/26/07

260

QC

Quality Control

Memo

0.00

(HO
PH)

270

270

Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD350-591-312
Location: Hall

6/14/12 (W)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: _____		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 16/01/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 09/03/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____

Date: _____ **Tooling:** _____

Date: _____

Run Start

NR1

QC: _____

Date: _____ **SPC (Y/N):** _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

280

QC21- Final Inspection - Work Order Release

280

QC

Quality Control

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

0.00

0.00

MLJ 12/03/08

12-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

January-16-12 7:41:41 AM

Page 1

Work Order ID: 78783

78783

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	30.0000	1	10			
D3272-1									**				<i>12.02.13</i>

		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
ST	<u>B78788</u>	-10			
WA		40			<u>10</u>
	77650	10			
	77651	10			
	77653	10			

D3067-1		Manufactured	No			110	Each	127.0000	1	10			
D3067-1									**				<i>12.02.13</i>

		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
WA	<u>B79407</u>	120			
	78022	120			
WA016		7			
	67582	2			
	68214	1			
	76179	4			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1

Manufactured No

110

Each

78.0000

2

20

**

12/02/13

D3219-1

Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA016 <u>B78763</u>	78	20
73410	12	
76226	14	
77674	52	

D3066-1

Manufactured No

180

Each

96.0000

2

20

**

~~B79419 X 7~~ Ae 12/02/23

~~B78797 X 3~~

~~B79729 → X20~~

D3066-1

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	70	
77564	70	
WA015	26	
76180	26	

MS20600-AD4W4

Purchased No

180

Each

2,386.000

16

160

**

B120308 160 Ae 12/02/23

MS20600-AD4W4

Rivets

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST321	2381	
116188	59	
117364	253	
117601	200	
117885	195	
118840	1089	
119860	30	
119883	555	
WA018	5	
116712	5	

W/O:		WORK ORDER CHANGES							
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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180

Each

12.0000

1

10

**

D3065-041

Step Leg Assembly Hi

B79419 (x7) Ae 12/02/23
B78797 (x3)

D3067-1

Manufactured No

180

Each

127.0000

1

10

**

D3067-1

End Plate

12.02.28

AN3-35A

Purchased No

250

Each

243.0000

1

20

**

D3235-1

Manufactured No

250

Each

47.0000

2

20

**

D3235-1

Mounting Lug

B78787 12/3/2012 10

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured

No

250

Each

11.0000

1

10

1

9

**

B71657

B7879W

D3278-041

Support Assembly

Location	Loc Qty	Loc Code
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ST481	11	
-------	----	--

76169

11

AN960JD416

NAS1149D0463J Purchased

No

250

Each

0.0000

16

160

**

M120644

Washer

AN960JD516

NAS1149D0563J Purchased

No

250

Each

0.0000

4

40

**

M112614

Washer

AN5-36A

NAS1149D0563J Purchased

No

250

Each

245.0000

2

20

**

S1

Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

ST340	245	
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119641

45

120187

200

D2618

Manufactured

No

250

Each

152.0000

2

20

**

B78537 12/3/17 S1 10

Bushing

Location	Loc Qty	Loc Code
----------	---------	----------

ST012	152	
-------	-----	--

76130

52

77563

100

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250

Each

72.0000

4

**



B79593

D2230-3

Lug
HD

Location Loc Qty Loc Code

ST480	72	
53881	4	
70973	1	
75546	1	
76642	66	

D2856-400

Manufactured No

250

f

113.7673

1.2

12_{10.40}

**

B79551



Abraison Strip

Location Loc Qty Loc Code

ST409	113.767258	
63735	0.6696	
68076	0.3149	
71164	21.66	
73491	91.122758	

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250

Each

5,839.000

2

**

20
23/7



MS210421 3

Out

Location Loc Qty Loc Code

ST300	5839	
117441	16	
117885	32	
118451	5	
118927	3	
119017	5309	
119075	474	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-16-12 7:41:41 AM

Page 6

Work Order ID: 78783

78783
D350-591-312

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 16/01/2012

Required Date: 09/03/2012

AN4-13A

Purchased

No

250

Each

1,478.000

8

80

**

AN4-13A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	1478	
119449	478	
120187	1000	

MS21042L5

Purchased

No

250

Each

2,018.000

2

80

**

MS210421 5

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	2018	
116105	5	
116548	43	
117611	50	
118179	420	
119109	1500	

MS21042L4

Purchased

No

250

Each

7,507.000

8

80

**

MS210421 4

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	7507	
117441	67	
117601	342	
118451	133	
119017	1965	
119075	5000	

AN960JD10

NAS1149D0363J Purchased

No

250

Each

0.0000

4

80

**

AN960.JD10

Washer

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04-*ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

7.8.783. M.C.J
12/01/16

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

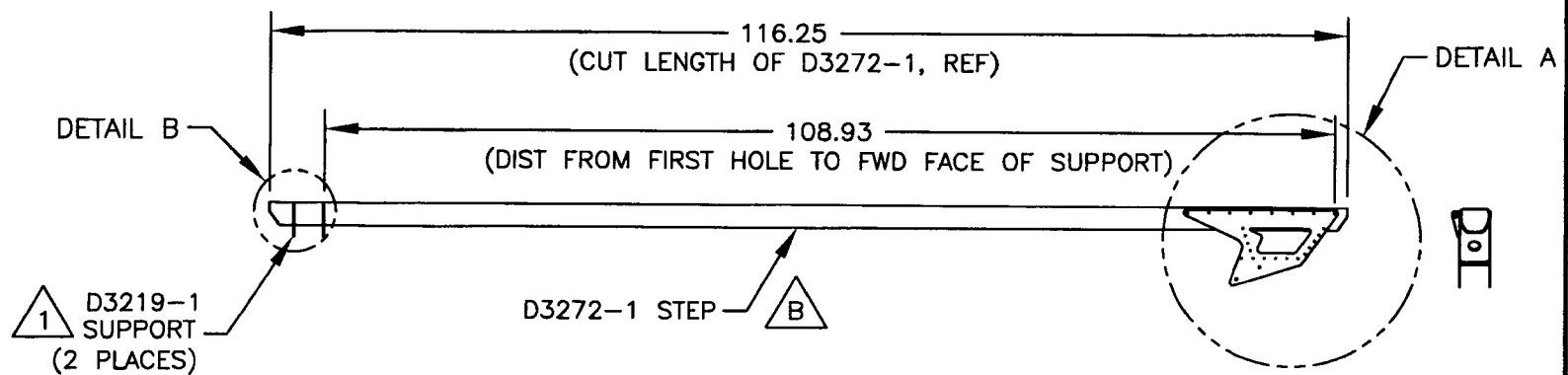
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

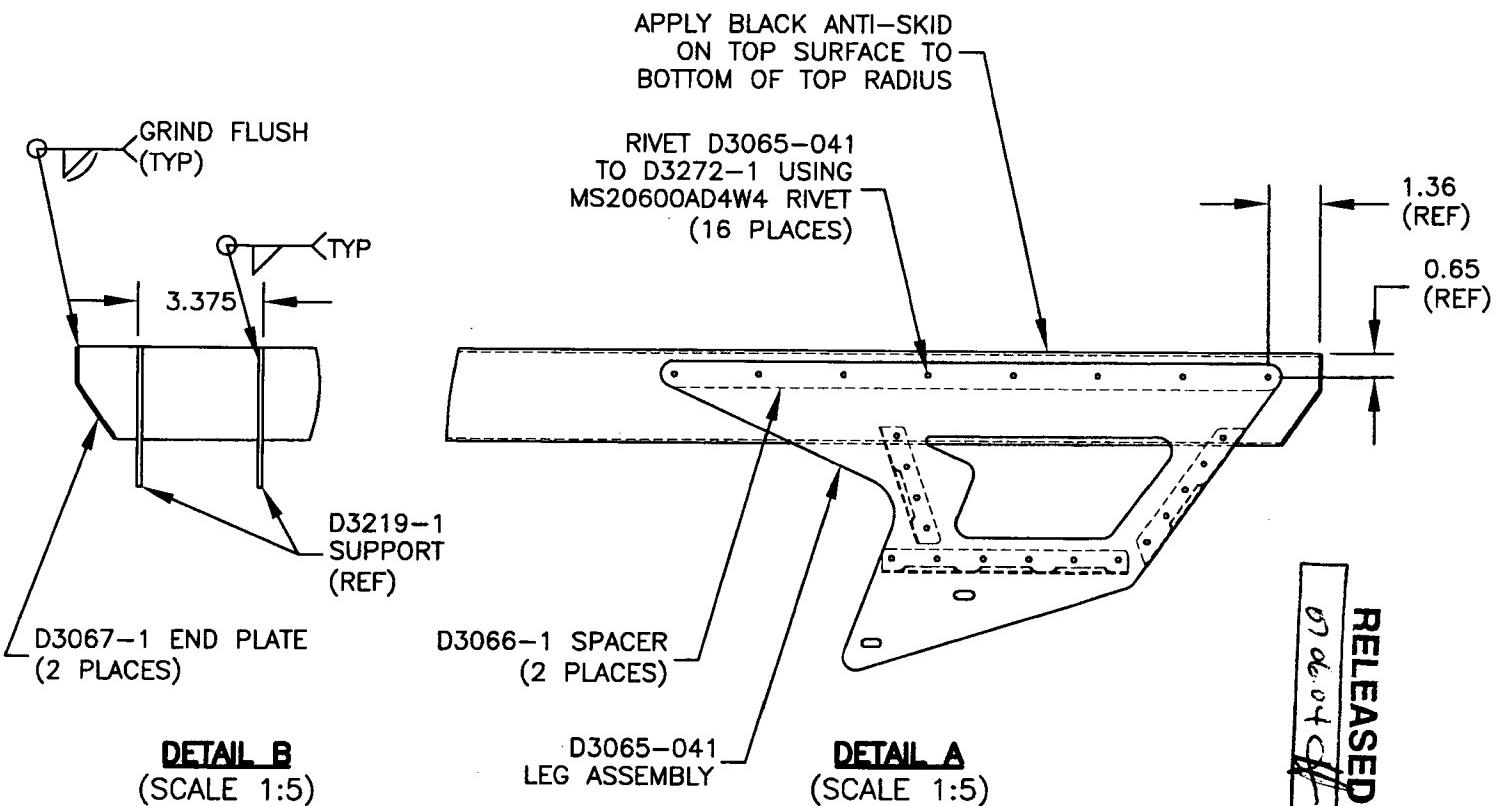
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78783



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07 dec 04 C/H

DESIGN	DRAWN BY	DART AEROSPACE LTD
97	JB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CE		D3272
DATE		SCALE
07.05.18		1:20
		SHEET 2 OF 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

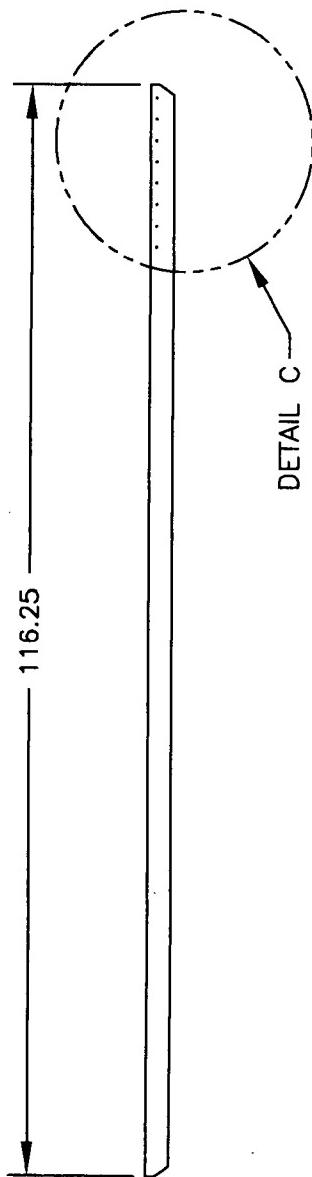
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

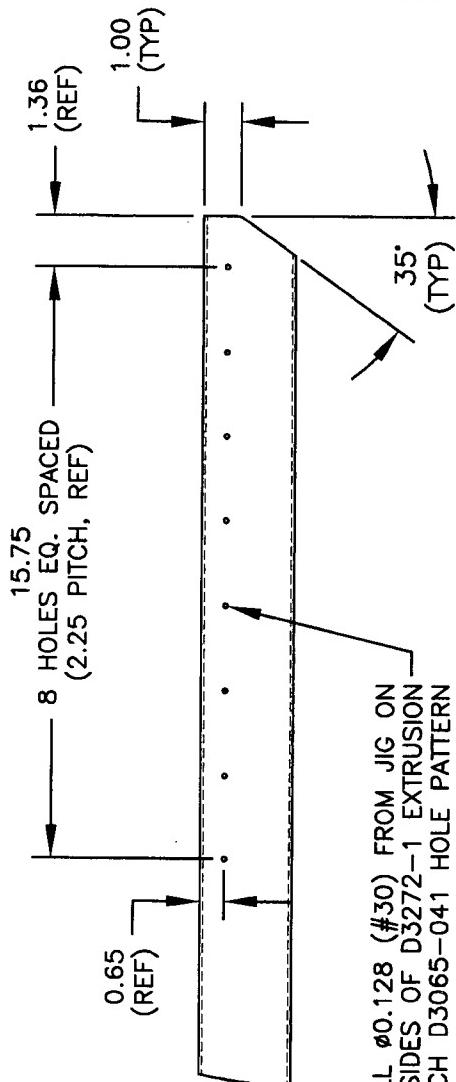
NOTE: Date & initial all entries

Notes
DART

DESIGN <i>GP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

RELEASED

07.06.04 *[Signature]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step - High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step - High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step - High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step - High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step - Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step - Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step - High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step - High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4		D2230-3	MOUNTING LUG
8	8					2	2	D2274	RADIUS BLOCK
								D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4					2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore NOT REQUIRED to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.